



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D206-642-341BL
Job Sheet 170523



Part No: D206-642-341BL

Job Qty: 1 ea

Part Name: Replacement Skidtube (Fits LH or RH)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 1/17/18

Job Tracking No:

Due Date: 1/31/18

Created By: Linda Lacelle

Type: SOLD

Description:

Ship Via:

Bill of Materials

DART
AEROSPACE
S033909



Replacement Skidtube (Fits LH or RH)

PART NO:

D206-642-341BL

Original Serial #: S033909

Revision:

Operation:

Change No:

Start up Operation
CHG005

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

01/19/18
Job No: 170523

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		1/25/18	0.00	0.00	Start Up Skidtubes-1		
110	Skidtubes	1 pcs		1/25/18	0.00	1.58	Skidtubes-2		
115	QC	1 pcs		1/25/18	0.00	0.00	QC5		
116	QC	1 pcs		1/25/18	0.00	0.00	QC9		
120	HandFinish	1 pcs		1/25/18	0.00	1.17	HandFinish1		
125	QC	1 pcs		1/25/18	0.00	0.00	QC7-1		
130	Skidtubes	1 pcs		1/25/18	0.00	1.58	Skidtubes-2		
140	QC	1 pcs		1/25/18	0.00	0.00	QC5		
150	Skidtubes	1 pcs		1/25/18	0.00	1.58	Skidtubes-2		
180	QC	1 pcs		1/25/18	0.00	0.00	QC5		
190	HandFinish	1 pcs		1/26/18	0.00	1.17	HandFinish2		
200	Outsource	1 pcs		1/30/18			ATE003-VC	3	
205	QC	1 pcs		1/30/18	0.00	0.00	QC6		
210	QC	1 pcs		1/30/18	0.00	0.00	QC14		
220	HandFinish	1 pcs		1/31/18	0.00	1.17	HandFinish4		
230	QC	1 pcs		1/31/18	0.00	0.00	QC3		
240	QC	1 pcs		1/31/18	0.00	0.00	QC5		
245	DC	1 pcs		1/31/18	0.00	0.00	DC		
250	Packaging	1 pcs		1/31/18	0.00	0.00	Packaging3-1		
260	QC21-FG	1 Ea		1/31/18	0.00	0.00	QC21		

Part Op 110 - 1-Deburr Fwd edge of tube 2-Scribe "Identify Batch Number" 3-Remove ridge on inside of Fwd edge of tube as per Descriptions: Dwg D2650 4-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required. A/R Aluminum Rod 5-Grind weld flush to cap on top surface only. 6-Cut aft end to length as per dwg D2650 7-Drill pilot holes using drill Jig DT8168A (A, & B) and DT8025. 8-Drill holes for wearplates using DT 8028-5. Open to Ø 0.297". 9-Open Aft Cap Hole using #6 Drill Bit 10-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-5 Drilling Detail 11-Remove inner indexing ridge on aft end of skidtubes as per Dwg D2650 12- Ream holes to finished size as per Dwg D2650, D2650-5 Drilling Detail (without cutting fluid) 13-Deburr.

130 - 1- Bond D2654-5 web in place as per QSI 015 Ensure holes line up Allow 12 Hrs. cure time before cutting Start Date: 22 Jan Time: 8:30 Finish Date: _____ Time: _____ A/R Sikaflex-291 1803

Sikaflex expiry date: 2018-04-21

150 - 1- Insert D4720-1 Spacer. Swage to 0.313" X 0.75" DP per QSI 002. Trim and grind flush per QSI 002

200 - ISSUE PO ***MASK ALL SADDLE AND GROUND HANDLING ATTACHMENT HOLES AS PER PAR16-484*** Make sure Nut Plate Thread is protected using paint screw, and mask GHW studs. PRIME: Start Time: _____ Finish Time: _____ PAINT: DELFLEET BLUE _____ Start Time: _____ Finish Time: _____ CLEAR DELFLEET B _____

220 - 1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate. A/R Sikaflex-291 M138555 Sikaflex expiry date: 18/03 2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive 3-Install MS27039-4-06 Screw 4-Inspect for foreign object per QSI 024 5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive A/R Sikaflex-291 M138555 Sikaflex expiry date: 18/03 6- Install D2680-041 Nut Plate as per Dwg D2650 7- Wing Walk as per Dwg D2650-5 and QSI 005 4.4 Batch: M138711

245 - Photocopy bluefile and create labels per PPP D206-642-341 CHG005

250 - Identify and pack for shipping as per PPP D206-642-341 Location:FG083

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2620 B163195	1	14	0	0
110-Skidtubes	D2647 B163996	5	5	0	0
130-Skidtubes	D2654-5 501680	1	13	0	0
150-Skidtubes	D4720-1 5014595	19	515	0	0
220-HandFinish	ALS4-1032-130 5007279	54	9,291	0	0
	CCR264SS3-3 FM137622	2	204	0	0
	CR3212-4-03 FM137886-0	2	216	0	0
	D2646BL 5013553	1	10	0	0
	D2651-1BL F164227	14	191	0	0
	D2651-3 F164834	14	559	0	0
	D2680-041 5013112	1	55	0	0
	D3537-1 5031939	6	66	0	0
	D3537-3 5013552	1	50	0	0
	D4956-11 5036400	1	2	0	0
	D4956-23 5026889	1	17	0	0
	D4956-35 5015949	1	12	0	0
	MS27039-1-08 FM138209-1	2	523	0	0
	MS27039-4-06 FM137451-1	1	95	0	0
	MS27039C1-08 5013448	54	190	0	0
	NAS1149C0332R 5027570	54	3,963	0	0
	NAS1149D0332J 5020606	2	446	0	0
	NAS1149D0463J FM137988	1	5,256	0	0

Part Specifications

Specifications could not be found.

Plex 1/17/18 7:55 AM dart.lacelle.linda

000247

QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
X				D2650-1	SKIDTUBE ASSEMBLY
	X			D2650-3	SKIDTUBE ASSEMBLY
		X		D2650-5	SKIDTUBE ASSEMBLY
			X	D2650-7	SKIDTUBE ASSEMBLY
1	1	1	1	D2600-1-160	EXTRUSION
1				D2654-1	WEB
	1			D2654-3	WEB
		1		D2654-5	WEB
			1	D2654-7	WEB
1	1	1	1	D2646	AFT CAP
1	1	1	1	D2647	CAP
17	18	19	23	D2649	CROSS BOLT SPACER
16	18	14	22	D2651-1	PLUG
16	18	14	22	D2651-3	O-RING
1	1	1	1	D2680-041	NUT PLATE
2	2			D3286-1	DOUBLER
2	2			D3286-3	STUD
42	44	54	60	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130)
2	2	2	2	AN960JD10L	WASHER
2	2	2	2	CCR264SS-3	RIVET
2	2	2	2	CR3212-4-03	RIVET
2	2	2	2	MS27039-1-08	SCREW
1	1	1	1	MS27039-4-06	SCREW
1	1	1	1	AN960JD416	WASHER
52	52			CR3212-4-04	RIVET



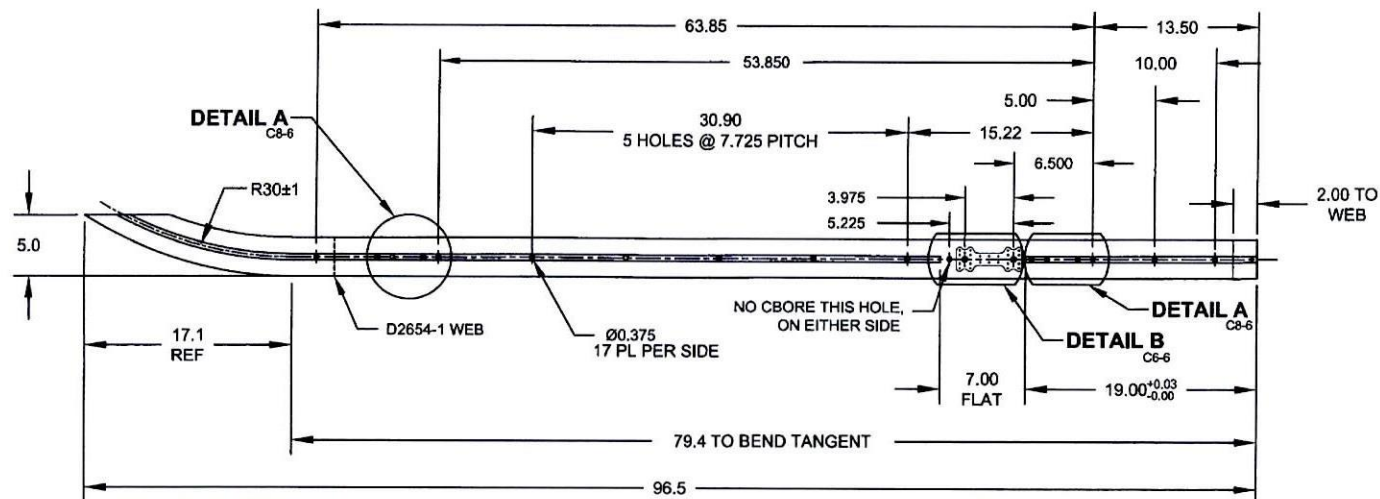
NOTES:

- MATERIAL: N/A
- FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- IDENTIFICATION: NONE
- WEIGHT: N/A
- WELD PER DART QSI 004
- DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/291 ADHESIVE PER DART QSI 015
- INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

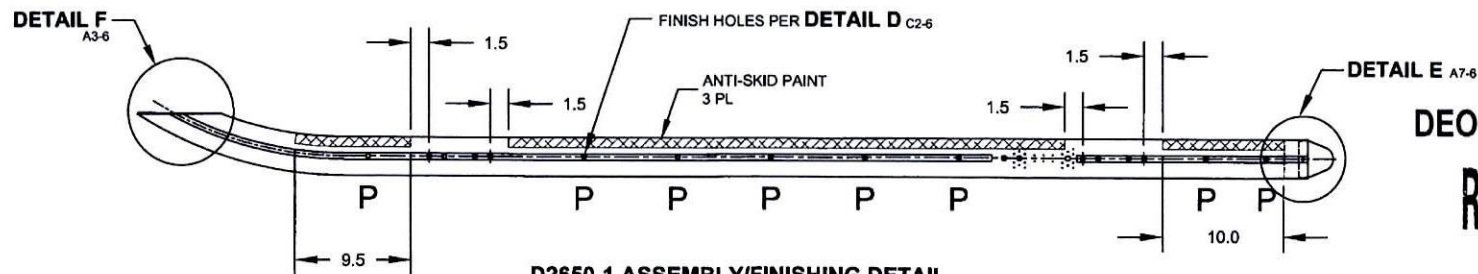
170523

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08-07-23

F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239).	AJS	08.08.08
E	REMOVE CBORE, CHG DRILL, ADD CHAMFER	CP	06.03.30
D	REDRAW: INCCRP. DE09136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3	CP	04.05.17
C	CHANGE HOLE PATTERN AND FRONT END	DS	97.10.29
B	AS MANUFACTURED CHANGES	DS	97.06.26
A	NEW ISSUE	DS	97.03.25
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 1 OF 8
APPROVED		TITLE	SCALE
DE APPR.		206/407 SKIDTUBE ASSEMBLIES	NTS
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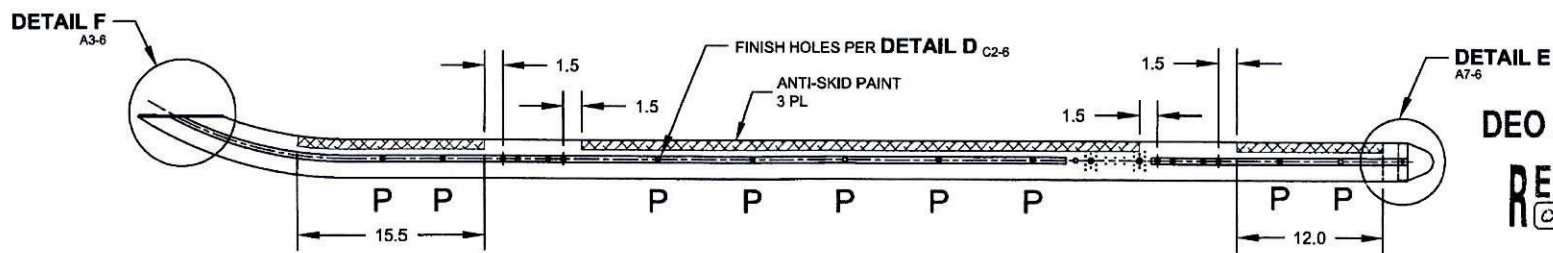
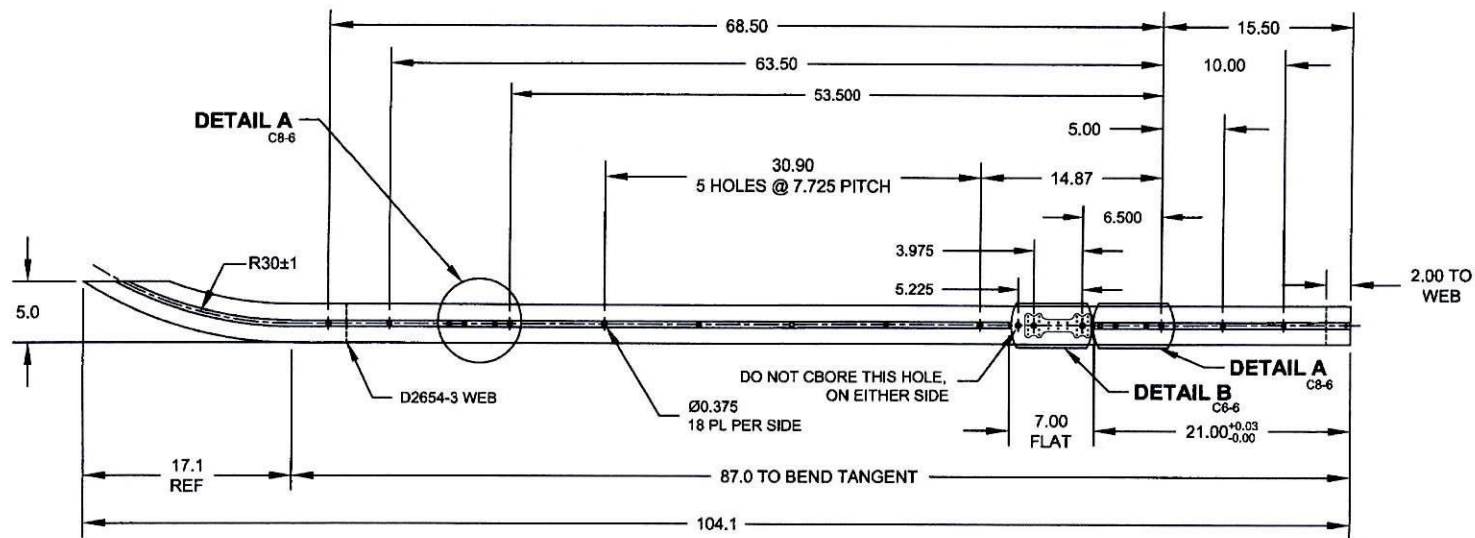


D2650-1 BENDING/DRILLING DETAIL



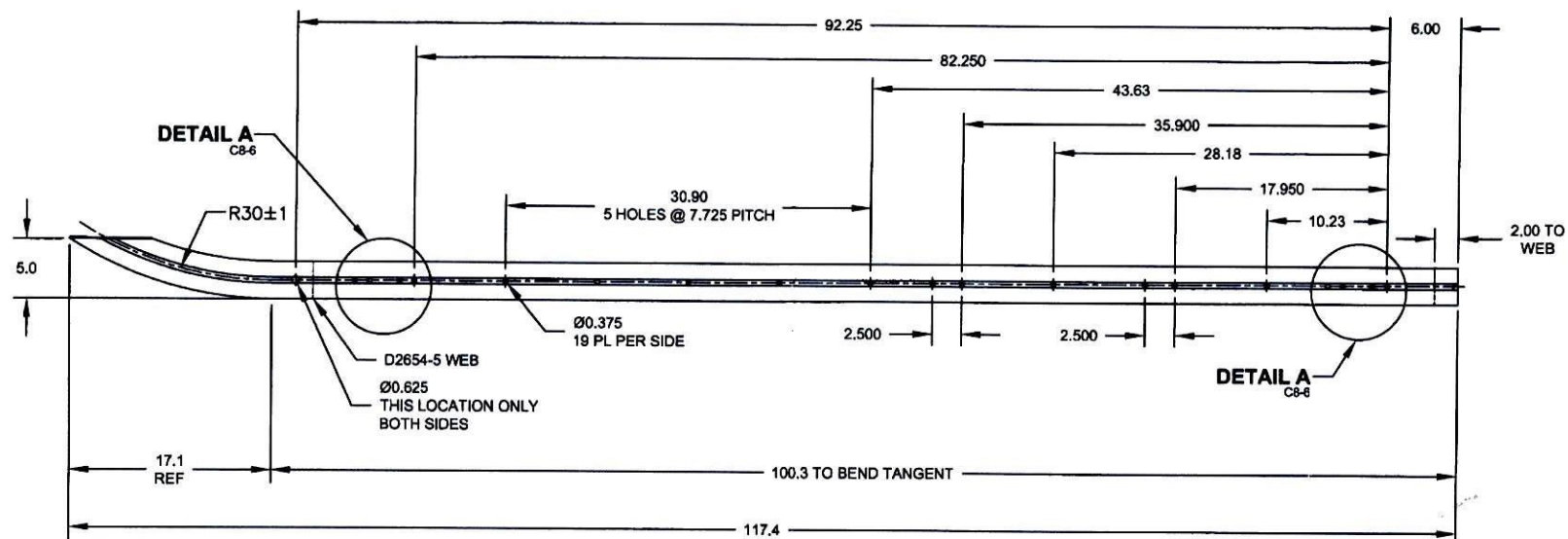
D2650-1 ASSEMBLY/FINISHING DETAIL

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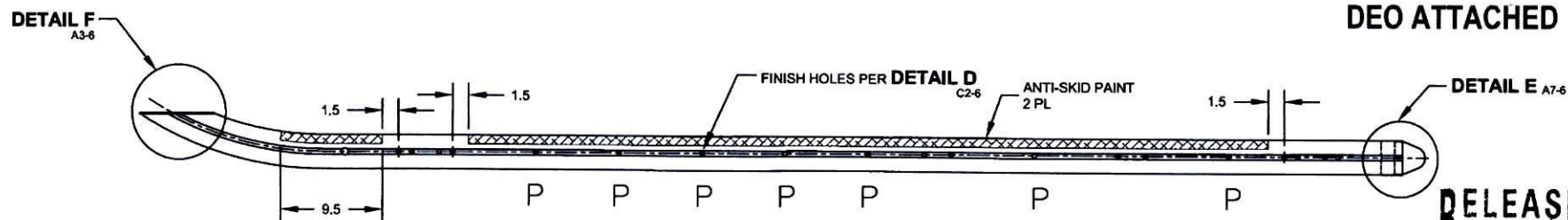


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08-07-22/118

DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 3 OF 6
APPROVED		TITLE	SCALE
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D2650-5 BENDING/DRILLING DETAIL

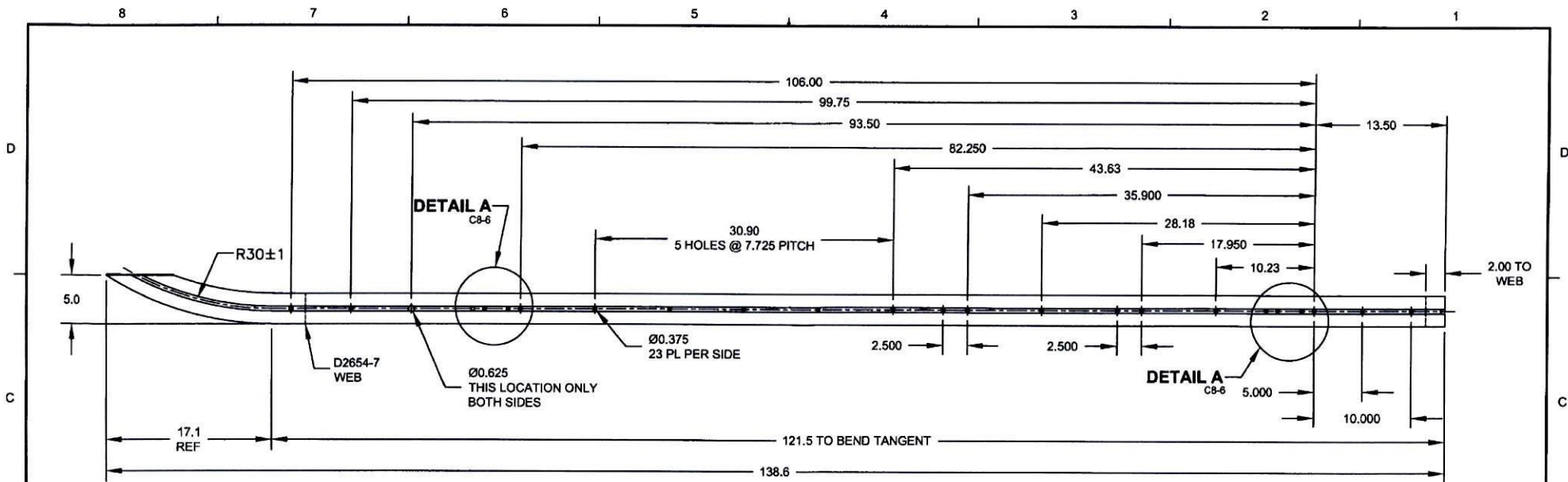


D2650-5 ASSEMBLY/FINISHING DETAIL

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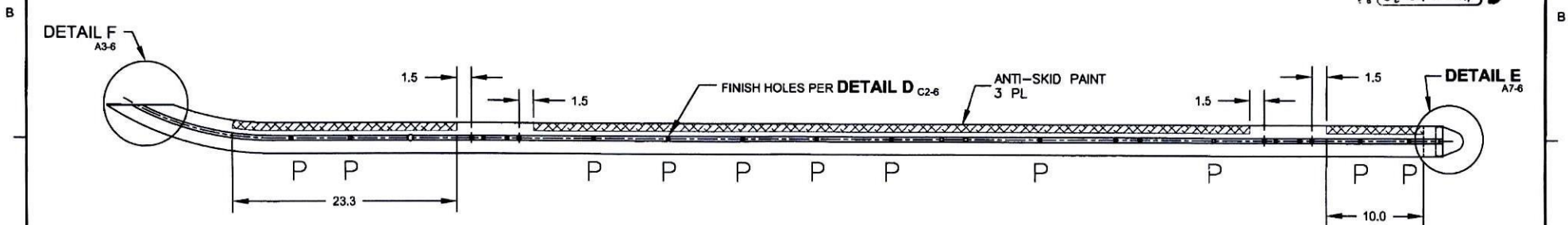
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DRAWN	AJS		
CHECKED	J	DRAWING NO.	REV. F
MFG. APPR.	J	D2650	SHEET 4 OF 8
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D2650-7 BENDING/DRILL DETAIL

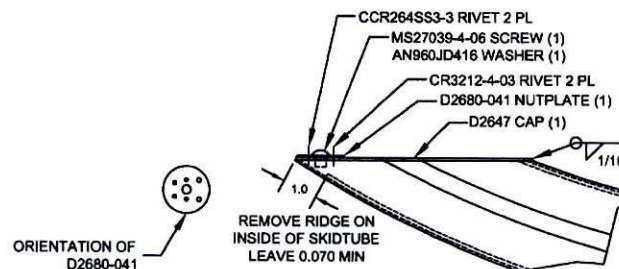
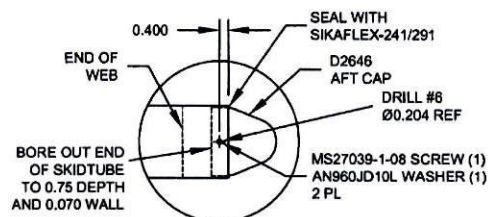
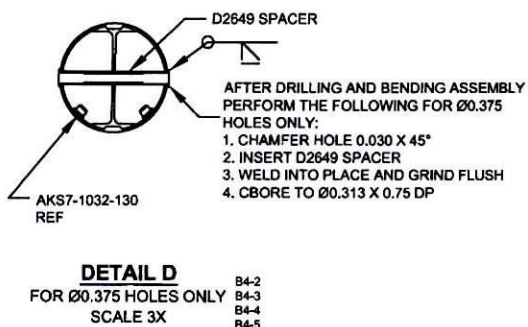
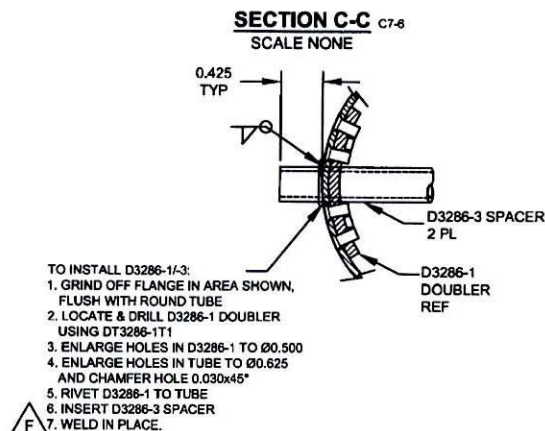
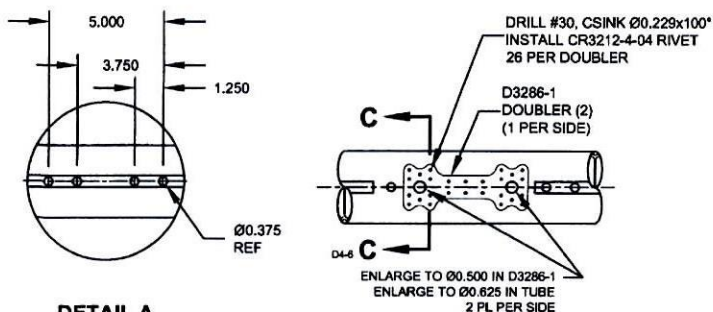
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D2650-7 ASSEMBLY/FINISHING DETAIL

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CHECKED	J	DRAWING NO.	REV. F
MFG. APPR.	E	D2650	SHEET 5 OF 8
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DE APPR.	H	206/407 SKIDTUBE ASSEMBLIES	NTS
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DETAIL F NOTES:

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D2680-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D2680-041 PRIOR TO FINISH

RELEASED
65 19 22-18
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DESIGN	DS	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2650	SHEET 6 OF 6
APPROVED		TITLE	SCALE
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DRAWING NO. D2650	TITLE 206/407 SKIDTUBE ASSEMBLIES	REV. F	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D2650-F-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>[Signature]</i>	CHECKED A.P.	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>		DE APPR. <i>[Signature]</i>		
DATE 12.10.12	DATE 12.10.22	DATE 12.10.22	DATE 12.10.22		DATE 12.10.22		

PURPOSE:

CHANGE C'BORED WELDED CROSSBOLT SPACERS TO SWAGED SPACERS

CHANGE:

PARTS LIST IS AMENDED AS FOLLOWS:

IS:

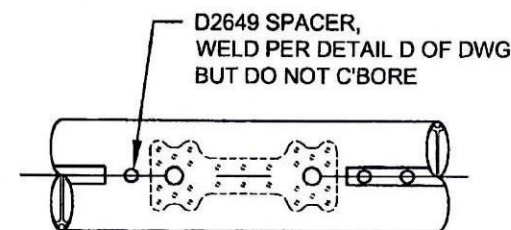
QTY -1	QTY -3	QTY -5	QTY -7	PART NUMBER	DESCRIPTION
1	1	0	0	D2649	CROSS BOLT SPACER
16	17	19	23	D4720-1	SPACER

WAS:

17	18	19	23	D2649	CROSS BOLT SPACER
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ADD DETAIL G BELOW, WHICH IS THE SAME SECTION VIEW AS DETAIL D OF DWG.

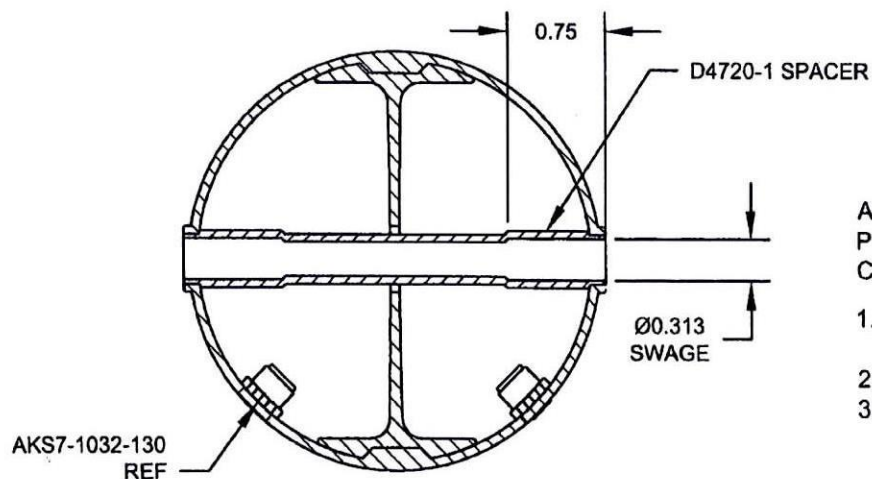
C'BORED HOLES ARE **NOW SWAGED** PER DETAIL G BELOW. FOR THE Ø0.375 HOLE THAT IS NOT C'BORED, WELD PER DETAIL D OF DWG (SEE AMENDED DETAIL B FOR REFERENCE).



DETAIL B

AMENDMENT TO DETAIL B
NOT TO SCALE

RELEASED
2012-11-16
[Signature]



DETAIL G

FOR Ø0.375 HOLES ONLY
FOR HOLES THAT ARE CURRENTLY C'BORED ONLY
NOT TO SCALE

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375 HOLES THAT ARE
CURRENTLY C'BORED:

1. INSERT D4720-1 SPACER, 16 PL (-1) OR 17 PL (-3)
OR 19 PL (-5) OR 23 PL (-7)
2. SWAGE TO Ø0.313 X 0.75 DP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002